

Date: Thursday, 4/12/2007 9:33:24 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 31781	
Estimate Number : 10224	
P.O. Number : N/A	Part Number : D2143
This Issue : 4/12/2007 S.O. No. : N/A	Drawing Number : D2143 REV. C1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 28948	Material : N/A
Written By : _____	Due Date : 5/10/2007 Qty: 20 Um: Each
Checked & Approved By : <u>4/07.04.12</u>	
Comment : Est C 00.05.18 Added inspection level 8 EC	
Est Rev:D Now on WaterJet 06-10-15 JLM	

Additional Product:

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0693 sf(s)/Unit Total : 1.3860 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S.040)

Batch:

M101275 (22) (5052)
 M19380 (20) (6061) SAN 07/05/08

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2143

Dwg Rev: C1

Prog Rev: C1

2-Deburr if necessary

SAN 07/05/08

42
 OTO

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/05/08

42

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAN 07/05/08

42

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble and Deburr

SAN 07/05/08 (42)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2143 PAR #: NA Fault Category: Prod / Ins. Ass. made small NCR: Yes No DQA: D Date: 07/05/30
 QA: N/C Closed: A Date: 07.05.30

NCR: <u>31781</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/08	2.0	Scrap 15 pieces because of program malfunction and offset and also mixing tube	<i>[Signature]</i>	Scrap - destroy and replace	SAD 07/05/08	<i>[Signature]</i> 07/05/08	<i>[Signature]</i>	<i>[Signature]</i> 07/05/08
07.05.08	1.0	MATERIAL USED IS 6061-T6 (REF. 116061T65040) W/STAND OR 11505211325-040, QTY. 20	<i>[Signature]</i> 07.05.08	DEVIATION IS ACCEPTABLE BECAUSE BASED ON HIGHER TENSILE STRENGTH OF 6061-T6 MAT'L.	SAD 07/05/09	<i>[Signature]</i> 07-05-29	<i>[Signature]</i>	<i>[Signature]</i> 07-05-29

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 31781

Part Number: D2143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SD

07/05/23

(42)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-23

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF

07-05-28

(42)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 103/41

BR/M-L

07-05-29

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

LU 7/5/30 SD

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 210

LU

7/5/30

SD

(42)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



LU 07-05-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31781
Description: Hinge Bracket		Part Number:	D2143
Inspection Dwg: D2143 Rev: C1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.340	+/-0.010	0.339	✓		Vern	
0.625	+/-0.010	0.630	✓		height gauge	
1.000	+/-0.010	1.004	✓		Vern	
R0.063	+/-0.010	R0.063	✓		R-b	
2.656	+/-0.010	2.664	✓		height gauge	
3.317	+/-0.010	3.318	✓		Vern	
Ø0.257	+0.005/-0.000	Ø0.258	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.175	✓		Vern	
1.660	+/-0.010	1.661	✓		Vern	
2.844	+/-0.010	2.852	✓		Vern	
1.659	+/-0.010	1.661	✓		height gauge	
R0.125	+/-0.010	R0.125	✓		R-G	
2.312	+/-0.010	2.318	✓		height gauge	

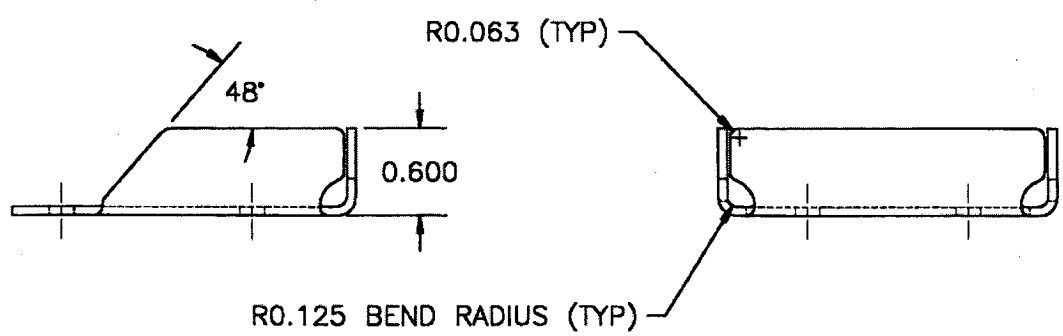
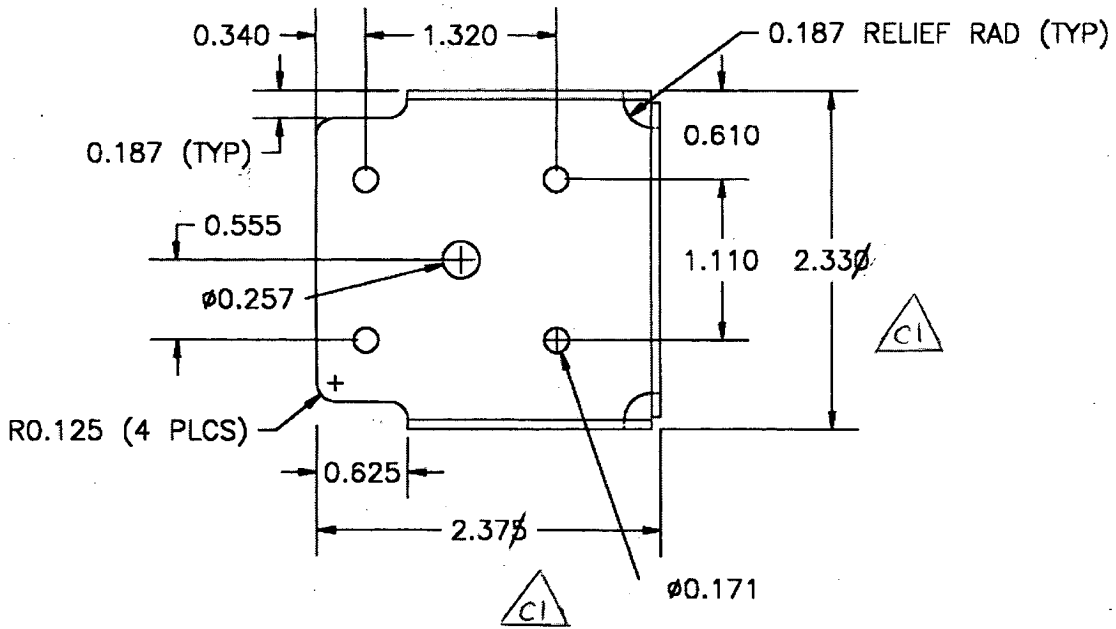
Measured by:	SAD	Audited by:	EG	Prototype Approval:	N/A
Date:	07/05/08	Date:	07.05.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	SAH



RELEASED
96.06.26 15.03

DESIGN	J BRADLEY	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
CHECKED	BW	APPROVED	BW	DRAWING NO. D2143	SHEET 1 OF 2
DATE	92.07.10	TITLE	HINGE BRACKET	SCALE	
	B	96.06.06	ADD FLAT PATTERN		
	C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK		
	CI	04.06.15	UPDATE DIMENSIONS		



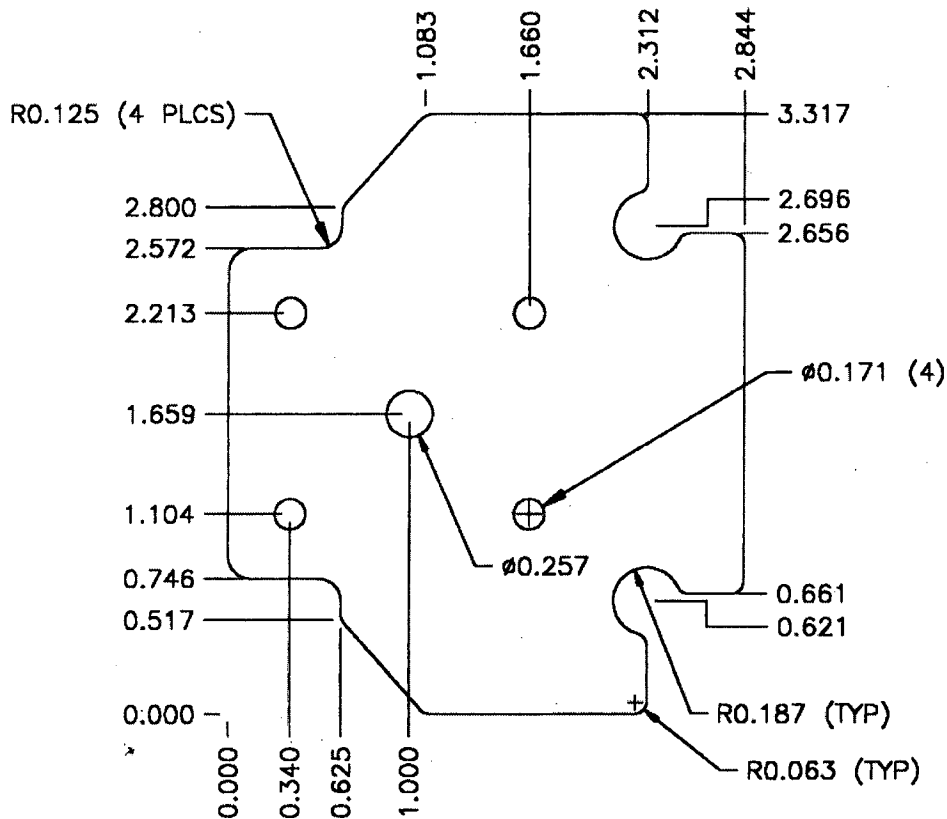
MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31781



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. a
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE	TITLE	SCALE	
95:10:18	HINGE BRACKET FLAT PATTERN	1:1	

RELEASED
96 66 20 BW



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WORK ORDER
NO. 31781

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317

DART AEROSPACE LTD		Work Order: 31781
Description: Hinge Bracket		Part Number: D2143
Inspection Dwg: D2143	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.340	+1.0.010	0.342	✓		Vern	
B 0.625	+1.0.010	0.628	✓		height gauge	
C 1.000	+1.0.010	1.002	✓		Vern	
D R0.063	+1.0.010	R0.063	✓		R-6	
E 2.656	+1.0.010	2.656	✓		Vern	
F 3.313	+1.0.010	3.322	✓		Vern	
G Ø0.257	+0.005 -0.001	Ø0.257	✓		Vern	
H Ø0.171	+0.005 -0.001	Ø0.174	✓		Vern	
I 1.660	+1.0.010	1.661	✓		Vern	
J 2.844	+1.0.010	2.847	✓		Vern	
K 1.659	+1.0.010	1.658	✓		Vern/height gauge	
L R0.125	+1.0.010	R0.125	✓		R-6	
M 2.312	+1.0.010	2.309	✓		height gauge	
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: SG	Prototype Approval:	N/A
Date: 07/05/08	Date: 07-05-08	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved